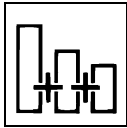
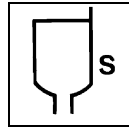


## LS143 (29143) ACRYL 2K



1000 ml +  
250 ml +  
300-500 ml

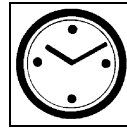
Pot life at 20° C:  
4 h



15-16" FC 4  
at 20° C



Ø 1,4 mm  
4 bar  
HVL P:  
Ø 1,2-1,4 mm  
2-2,5 Atm  
N° coats: 2



Air drying at 20° C  
Handling: 6-8 h  
Through-drying: 48 h  
Low bake at 60° C:  
30 min.

### DESCRIPTION

Two-pack acrylic enamel with direct adhesion to the substrate for internal and external use.

### USE

Suitable for painting metal and plastics in the Industry field.

### CHARACTERISTICS

- Easy application
- Excellent appearance
- Good chemical resistance
- Very good scratch resistance
- Very good adhesion to:
  - steel (the product does not contain any anticorrosive pigments; protection due to barrier-effect)
  - stainless steel
  - zinc coated steel (EG and HDG)
  - aluminium and light alloys
  - brass
  - zinc alloys
  - FGRP (polyester + fibreglass)
  - phenolic resins and urea resins
  - nylon (PA) \*
  - polyurethane resins (PUR)
  - carbon fibre

\* Use the hardener 29343 LECHSYS ISOLACK ESP INDUSTRY HARDENER at the same quantity as of 29342 (25%).

### SUBSTRATE PREPARATION

**Steel, aluminium and its alloys, brass, and zamac (zinc+aluminium+magnesium):** Degrease with 00695 SILICONE REMOVER SLOW and slightly sand with Scotch Brite.

**PRFV, phenolic and urea resins, carbon fibre, PU and PA:** Degrease with 00617 PLASTIC CLEANER .

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## APPLICATION

Spray.

### Mixing ratio:

LS143 ACRYL 2K (derived from binder 29143)

29342 LECHSYS ISOLACK HARDENER or

29360 INDURITORE NG1 (hardener)

00824 (Slow) -00825 (Standard) LECHSYS UNIVERSAL THINNER

### weight and volume

1000 parts

250 parts

300 - 500 parts

Pot life at 20 °C: 4 hours

Spray viscosity at 20 °C: 15 - 16" FORD Cup 4

Ø Air cap: 1.4 mm; HVLP 1.2 - 1.4 mm

Air pressure: 4 Atm; HVLP 2 - 2.5 Atm

Number of coats: 2

Film thickness: 25 - 30 µ

Theoretical coverage : 1 l mixture = 14 m<sup>2</sup> at 30 µ

1 kg mixture = 12,5 m<sup>2</sup> at 30 µ

V.O.C. (on average) of the product ready for use: ~ 520 g/l

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## DRYING TIME

### Air drying at 20 °C

Dust-free: 30-40 min.

Handling: 6-8 hours

Through-drying: 48 hours

### Low bake at 60 °C:

30 min. (after 20-30 min. flash-off at 20°C)

The curing continues for the following 3-4 days.

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## OBSERVATIONS

To accelerate the product hardening in cold conditions, add 09167 SPEED-O-DRY ADDITIVE (max 5%).

**N.B.: For production by mixing machine it is recommended to stir the product immediately after adding the tinters.**

Colour formulations containing the tinters 29044 and 29046 must be ONLY used on paint substrates NOT directly exposed to sunlight.

In case of substrates exposed to sunlight, use alternative formulations (High Resistance or Ecological Formulations) available on Lechler Explorer (MAP).

The use of UV Plus Additive 33333 (up to 5% in the topcoat) allows you to further improve resistance to sunlight.

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## MATT & GLOSS TABLE

The enamels of the Acryl 2K family are available in different gloss levels:

MATT 3/7 GLOSS	SEMI MATT 7/15 GLOSS	SATIN MATT 15/25 GLOSS	SEMI GLOSS 30/45 GLOSS	GLOSS 50/75 GLOSS	HIGH GLOSS ≥80 GLOSS
	LS153	LS404	LS405	LS406	LS143

## TECHNICAL DATA SHEET N° 0397-GB

UPDATED 11/2019

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